

Work Order ID 66384

Monday, February 14, 2011 10:08:23 AM

Page 1

Item ID: D2938-2

Revision ID:

Item Name: Saddle RH Out, 206

Start Date: 2/14/2011 Start Qty: 4.00

Required Date: 2/25/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: *MP*

Date: *11-02-14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

11-3-4
B.A 11/03/07

4

0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

11-3-4
B.A 11/03/07

4

0

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

11-3-4
B.A 11/03/07

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Monday, February 14, 2011 10:08:23 AM

[illegible]

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[illegible]

1. The first two columns of the table are labeled "Year" and "Country".
 2. The third column is labeled "GDP per capita (US\$)".
 3. The fourth column is labeled "Life expectancy at birth (years)".
 4. The fifth column is labeled "Fertility rate (children per woman)".
 5. The sixth column is labeled "Infant mortality rate (per 1,000 live births)".
 6. The seventh column is labeled "HDI".
 7. The eighth column is labeled "Notes".

Customer:

[illegible][illegible]

Abstract

Stop

mf 11/03/01

[illegible]

0.00

Quality Control

H BR 11-3-9

HandFinish

Hand Finishing

Memo

0.00

0.00

[REDACTED]

SprayPaint

Spray Painting

Memo

Prime Delfleet Blue : B 115967
Paint Delfleet Blue : B 115985
Clear Delfleet : B 117113

0.00

11 03 10
10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2938-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>66384</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-03-17	145	product line of defleet changing to lower voc's supplier misinformed + sent wrong clear	↓ 11-03-16	scuff + re-clean update QSE 005 F3118 + F3921 1 to 1 # 1 to 1 mixture 3 parts	25 11-03-17	↓ 11-03-18 G1042	↓ 11-03-18 G1042	↓ 11-03-18 G1042
				1 part F 3210 1/2 part F330 ACCEPTABLE per ATTACHED EMAIL.				

NOTE: Date & initial all entries

Work Order ID 66384

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Monday, February 14, 2011 10:08:23 AM

Item ID:	D2938-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle RH Out, 206			Stop		
Start Date:	2/14/2011	Start Qty:	4.00			
Required Date:	2/25/2011	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish 214 Memo	0.00 0.00		50603108		(74)			
170 Packaging Packaging	Identify as per dwg & Stock Location: 421 Memo	0.00 0.00							4/13/21 (4)
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/3/21 (4)

11-03-21
(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 14, 2011 10:08:20 AM

Page 1

Work Order ID: 66384



Parent Item: D2938-2



Parent Item Name: Saddle RH Out, 206

Start Date: 2/14/2011

Required Date: 2/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	30.0000	1	4			
Saddle Billet, 7075													

Location

Loc Qty

Loc Code

MAT

20

65151

20

MAT042

10

65175

10

4.0

B.A 11/03/07

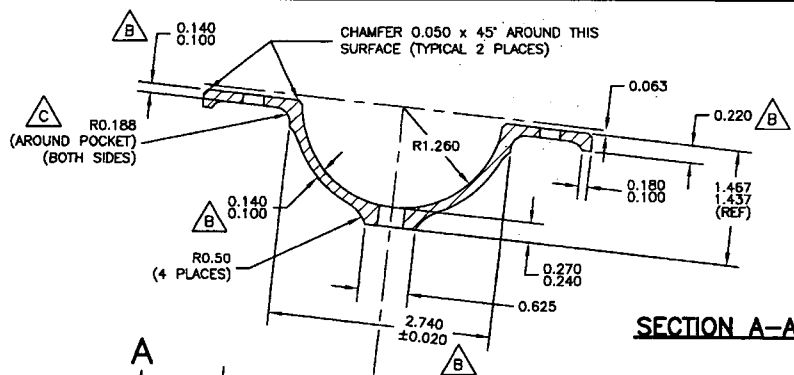
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

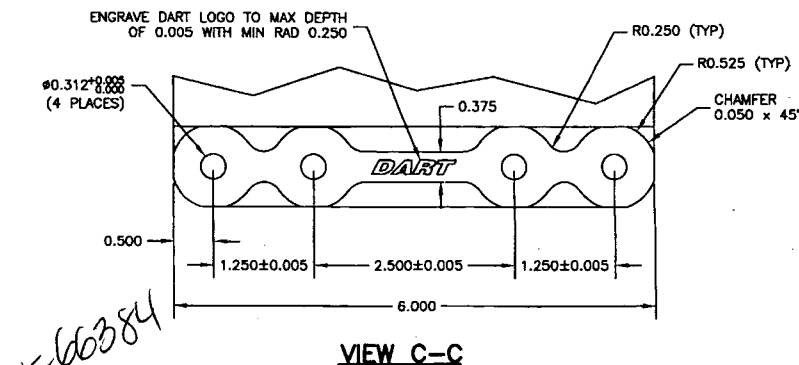
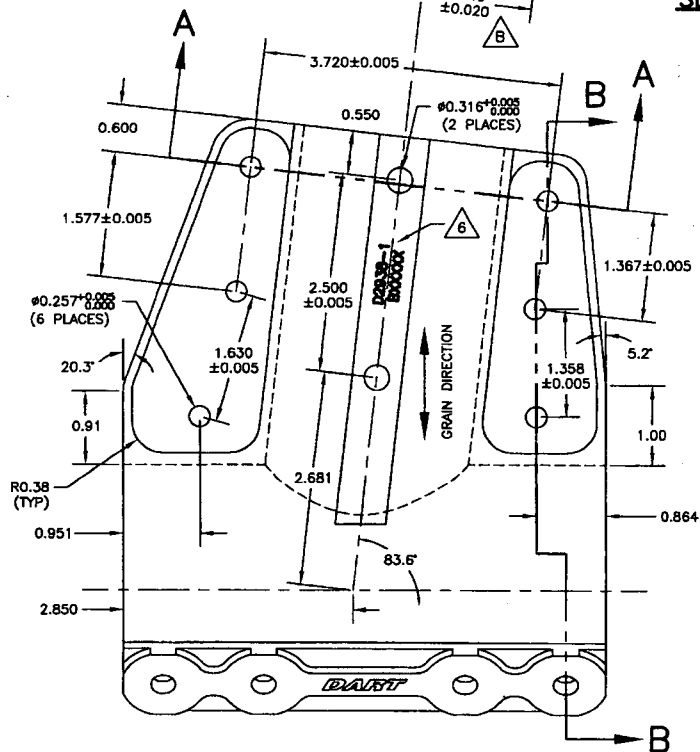
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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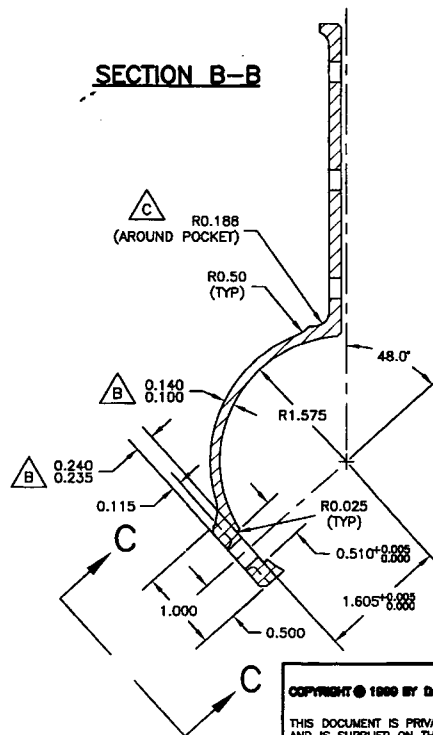


SECTION A-A



VIEW C-C

SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	SADDLE OUTSIDE
06.11.09		

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DART DART AEROSPACE USA, INC.

DRAWING NO. D2938

TITLE SADDLE OUTSIDE

2:3

07.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 66384
Description: 206 Saddle, Outboard, Right side	Part Number: D2938-2
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	0.116	0.117	0.115	Mic	100-119
B	0.100	0.140		.125	0.115	0.116	0.115	"	"
C	0.100	0.140		.129	0.117	0.125	0.125	"	"
D	0.210	0.230		.221	0.221	0.221	0.220	Vern	GA-01
E	1.245	1.255		1.250	1.250	1.250	1.250	"	"
F	1.245	1.255		1.250	1.250	1.250	1.250	"	"
G	2.495	2.505		2.500	2.500	2.500	2.500	"	"
H	0.510	0.515		.513	0.513	0.513	0.513	"	"
I	1.572	1.582		1.577	1.577	1.577	1.577	"	"
J	2.495	2.505		2.500	2.500	2.500	2.500	"	"
K	0.257	0.262		.257	0.260	0.260	0.260	"	"
L	0.312	0.317		.313	0.315	0.315	0.315	"	"
M	0.235	0.240		.234	0.239	0.239	0.239	"	"
N	0.100	0.140		.109	0.110	0.111	0.110	Mic	GA-03
O	0.540	0.560		.550	0.555	0.545	0.545	Vern	GA-01
P	0.490	0.510		.502	0.501	0.502	0.501	"	"
Q	3.715	3.725		3.720	3.720	3.720	3.720	"	"
R	2.720	2.760		2.740	2.741	2.741	2.741	"	"
S	0.240	0.270		.252	0.249	0.250	0.250	"	"
T	0.100	0.180		.135	0.135	0.135	0.135	"	"
U	1.625	1.635		1.630	1.630	1.630	1.630	"	"
V	1.362	1.372		1.367	1.367	1.367	1.367	"	"
W	0.316	0.321		.316	0.317	0.317	0.317	"	"
X	1.250	1.270		1.259	1.263	1.2615	1.2617	Dial	HAAS 2
Y	1.565	1.585		1.574	1.577	1.5759	1.5753	"	"
Z	0.178	0.198		.188	0.188	0.188	0.188	R-6	ref.
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>[Signature]</i>
Date: 11-2-4 / 11/03/07

Audited by: <i>[Signature]</i>
Date: 11/03/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Linda Lacelle

From: David Shepherd <dshepherd@dartaero.com>
Sent: March 18, 2011 11:14 AM
To: 'Marc Bellavance'; 'Linda Lacelle'
Subject: RE: D206-642-441B Skidtubes

Linda/Marc,

I was concerned that we had discovered a chemical incompatibility between the new paint and the clear and that is why we had to re-clear the skidtubes. Scuffing and re-clearing the skidtubes to a matte finish is acceptable to me.

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Friday, March 18, 2011 9:04 AM
To: 'Linda Lacelle'; 'Shepherd, David'
Subject: RE: D206-642-441B Skidtubes

Linda, please call David, he has one or a few questions for you...

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: March 18, 2011 9:32 AM
To: 'Marc Bellavance'; 'Shepherd, David'
Subject: RE: D206-642-441B Skidtubes

The skids were already scuffed, and the new clear was applied...these are suppose to ship today

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: March 18, 2011 9:25 AM
To: Shepherd, David
Cc: Lacelle, Linda
Subject: D206-642-441B Skidtubes
Importance: High

Good morning David,

Ian came to see me this morning re Delfleet product line changing to lower VOC's. The supplier was misinformed and sent us the wrong clear. Now the skidtubes must be scuffed and re-cleared. Also, this will affect QSI 005 since the mixture must be changed. A W/O NCR has been filled out by Ian on all the W/O's (but we need your approval on this prior to signing off them off.

Call me if you have more questions, I'll answer with what I have and know about this issue.

Thanks,

Marc Bellavance
Technical/Shop Support